

29.97

Dart Aerospace Ltd.

Date: Wednesday, 6/6/2007 3:04:56 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FITTING
Job Number : 32827	
Estimate Number : 11160	
P.O. Number : <u>N/A</u>	Part Number : D32571
This Issue : 6/6/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3257 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : MACHINED PARTS	Drawing Revision : A1
Previous Run : -28944	Material : <u>N/A</u>
Written By : _____	Due Date : 6/20/2007
Checked & Approved By : <u>[Signature] 07.06.07</u>	Qty: <u>20</u> Um: Each
Comment : Est: A 04.04.14 New issue KJ/RF	<u>30/06</u>

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M303B0500X0500	AISI 303 Bar .5 x .5
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Comment: Qty.: 0.1147 f(s)/Unit Total : 1.1466 f(s)  
 AISI 303 Bar .5 x .5  
 Material: AISI 303 SS Bar  
 (M303B0.500x0.500)  
 Identify for D3257-1  
 Batch: M17625

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW  
 Cut blank: 0.500" x 0.500" x 1.180" long Bar

SA 07.10.30

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
 Machine as per Folio FA420 and Dwg D3257  
 Deburr

SC 07.11.02

20

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SC 07.11.02

20

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SC 07.11.02

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PD Date: 27/11/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 6/6/2007 3:04:56 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 32827

Part Number: D32571

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*h 8.11.02 (20)*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*(20) 20/11/05*

Job Completion



*C207111/05*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	<b>32827</b>
<b>Description:</b> Fitting		<b>Part Number:</b>	<b>D3257-1</b>
<b>Inspection Dwg:</b> D3257 <b>Rev:</b> A1		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	.120/.132	✓			
0.135	+0.010/-0.007	.131	✓			
1.080	+/-0.010	1.082	✓			
0.330	+/-0.010	.330	✓			
0.385	+/-0.010	.385	✓			
Ø0.191	+0.005/-0.000	Ø.1905	✓			
R0.193	+/-0.010	.194	✓			
0.887	+/-0.010	.885	✓			
0.385	+/-0.010	.386	✓			
0.192	+/-0.005	.193	✓			
Ø0.230 x 100°	+/-0.010	.230	✓			
0.135	+0.010/-0.007	.131	✓			

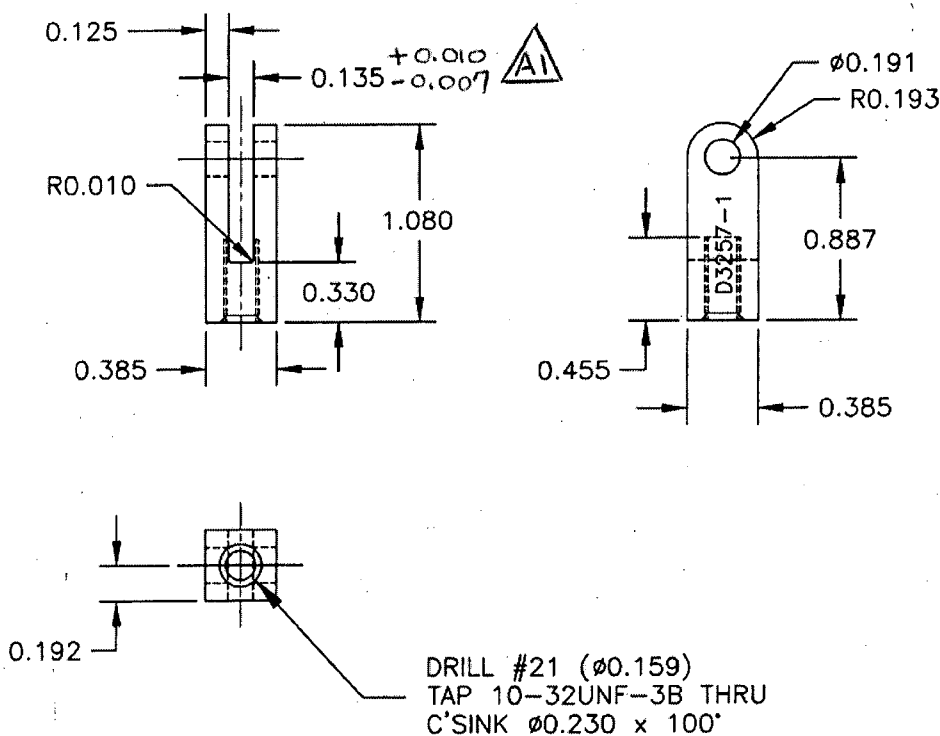
<b>Measured by:</b> <i>SK</i>	<b>Audited by:</b> <i>mf</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07.11.01	<b>Date:</b> 07/11/02	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.12.10	New Issue	KJ/JLM	
B	05.06.20	0.455 dimension removed	KJ/JLM	<i>mf</i>



DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3257	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE FITTING	SCALE 1:1
A	04.01.27	NEW ISSUE	
AI	<del>04.12.14</del>	ADD TOLERANCE	

RELEASED  
04.04.05



### D3257-1 FITTING

#### NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: AISI 303 SS, BAR (REF DART SPEC. M303B0.500X0.500)
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE DART P/N AS SHOWN

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 32827

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